

Work Order ID 50783

July 22, 2009 12:46:57 PM

Split



29/1/09

Item ID: D3891-041 -2

Revision ID: A

Item Name: Panel, Fwd LH

Start Date: 07/22/2009 Start Qty: 4.00

Required Date: 07/24/2009 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: *mf*

Date: 09-07-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3891	A

4

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3891-1

Dwg Rev: *2*

Prog Rev: *2*

2-Deburr if necessary

IB 9-7-23

④

IB 9-7-23

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Work Order ID 50783

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Item ID: D3891-041
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Item Name: Panel, Fwd LH

Accept



Setup Start



Stop



Start Date: 07/22/2009 Start Qty: 4.00
Required Date: 07/24/2009 Req'd Qty: 4.00



Cust Item ID:
Customer:



Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

⇒ Serials

(24)

φ

—

130



Small Fab

Small Fab

Memo

Debur if necessary

0.00

0.00

m-h 09/07/23

(4X)

140



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

alsh

mf 09-08-12

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Item ID: D3891-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Panel, Fwd LH

Start Date: 07/22/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00

4



Small Fab

Memo

0.00

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: M111428

M111428

m-k

09/07/24

(2x)

Small Fab

QC5- Inspect part completeness to step on W/O

0.00

09/08/07

(2x)

160



QC

Quality Control

Memo

0.00

=> 802/09/07

(2x)

p

170

0.00



Packaging

Identify as per dwg & Stock Location:

Memo

0.00

(2x)

9/4/7 sel

Packaging

Work Order ID 50783

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Item ID: D3891-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Panel, Fwd LH

Start Date: 07/22/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09-08-13

09-08-13

mf 09-08-11

Picklist Print

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July 22, 2009 12:46:56 PM

Work Order ID: 50783

Parent Item: D3891-041RevA

Parent Item Name: Panel, Fwd LH


Comments:

Start Date: 07/22/2009

Required Date: 07/24/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	709.8406	19.6042			
												
GE PLASTICS LEXAN SHEET												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

709.8406316

103106

7.8

105330

54

109455

0.03

111710

648.010632

D3891-3RevA

Manufactured

No

140

Each

0.0000

4.0000



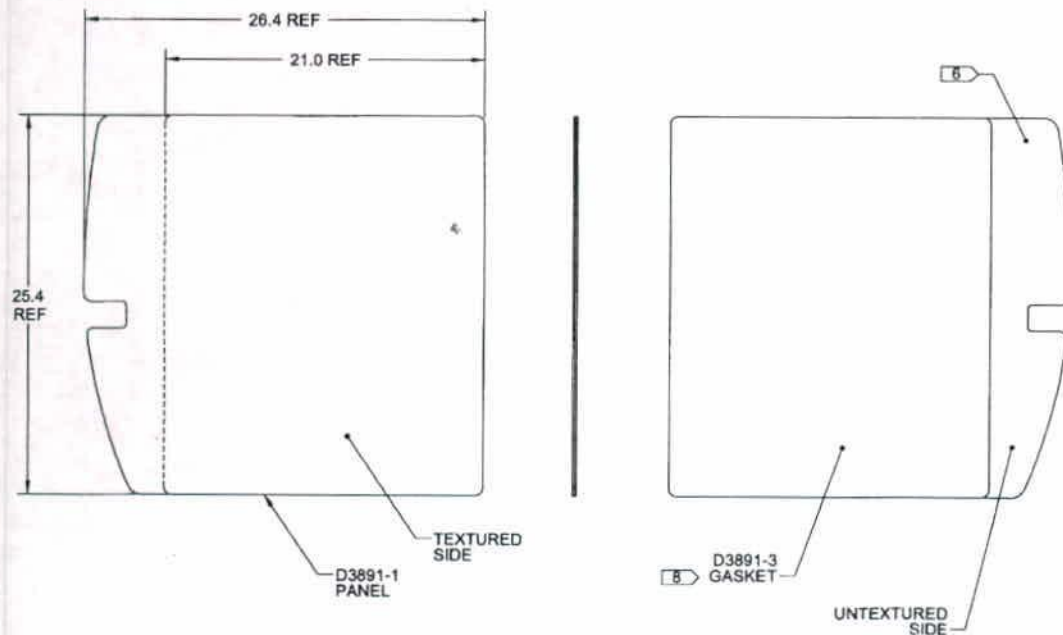
Gasket

111710 B 9-7-23

51176 MF 09-06-20

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-041 PANEL, FWD LH**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3891	REV. A
TITLE PANEL, FWD	SHEET 1 OF 6
SCALE NTS	
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RELEASED
C7/06/16 11/1

